

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007714**Date Inspected:** 16-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 3BW

This QA Inspector observed grinding of Magnetic Particle Testing (MT) indications on the floor beam diaphragm to floor beam flange at panel point 23.

Segment 2BW

This QA Inspector observed grinding of weld profile on the counter weight connection plates.

Segment 2AW/1BW

This QA Inspector observed carbon air arc gouging of temporary fit up plates along the transverse CJP splice weld.

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Segment 5BW/CB4

This QA Inspector observed grinding of the back gouged area of the hold back welds at the bottom splice plate to FL3 floor beam at panel point 34.

Segment 1AW

This QA Inspector observed grinding of the Deck Plate open rib stiffener plate ends at the beveled groove face at the 1AW/1AAW transverse splice connection.

Segment 2AE

This QA Inspector observed shielded Metal Arc Welding of a pad eye to the FL3 bottom plate at panel point 16.

Segment 3AW

This QA Inspector observed grinding of the ends of stiffener plates on Deck Plate at the Deck Plate to Cross Beam connection.

Segment 3BW

This QA Inspector observed ABF NDT personnel performing MT on the Corner Assembly Edge Plate Stiffener plate on the cross beam side and corner assembly side plate stiffeners on the counter weight side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
